

Work Order ID 71499

Tuesday, July 05, 2011 8:59:59 AM

Page 1

Item ID: D350-636-012

Accept

Revision ID:

Item Name: Skidtube RH

Start Date: 7/5/2011 Start Qty: 1.00

Required Date: 7/15/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PEP-D350-636-012-CHG 006

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



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Start Date: 7/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)								
	7- Check DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)								
	9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10- Open up holes of Detail A to 0.297" (total of 2 holes per side)								

B 11/07/12

Dr. 11/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: M115778

DE 11/07/13
BB 11/07/14

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Pro →

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-062 PAR #: _____ Fault Category: landing Gear skid run NCR: Yes No DQA: ck Date: 11/07/19
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11-07-20

NCR: <u>71498</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>1266.33</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/7/14</u>	<u>110</u>	<u>Found at inspection that the # 1st hole from A/H is not correctly aligning on the other side.</u>	<u>[Signature]</u> <u>11/07/14</u>	<u>SCRAP + DESTROY</u>	<u>[Signature]</u> <u>11-7-14</u>	<u>SAD</u> <u>11-07-14</u>	<u>[Signature]</u> <u>11/07/14</u>	<u>[Signature]</u> <u>11/07/14</u>
		<u>R.C. not Drilled correctly</u>						

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Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: _____
exp. date: _____

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: _____

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

220



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

230



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: _____

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241
BATCH: _____
EXP DATE: _____

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: _____

5-Coat all exposed fasteners with "LPS Procyon"
batch: _____

RESEARCH DESIGN AND METHODS

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Accept



Setup Start

Stop

1. **Author(s)**
 2. **Title**
 3. **Journal**
 4. **Volume**
 5. **Issue**
 6. **Page(s)**
 7. **Year**
 8. **DOI**
 9. **URL**
 10. **Accession Number**
 11. **Keywords**
 12. **Abstract**
 13. **Notes**
 14. **References**
 15. **Comments**
 16. **History**
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 254. **Help**

Cust Item ID:

10/10

Customer:

Reference:

Run Start

[illegible]

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool

Plan Code

**Accept
Qty**

Reject
QtyReject
NumberInsp.
Stamp

QC5- Inspect part completeness to step on W/O

0.00

00000000000000000000

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

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Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

MF
11-07-15

Picklist Print

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Work Order ID: 71499



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 10.09.25 Rearranged procedure steps [KJ]
IPP Rev: J 06-03-29 As per Rev D EC
IPP Rev: K 06-07-13 As per dsi9343 EC
IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC
IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
10.06.22 revise seq 110 DD verf: EC IPP Rev: P 10.10.01 as per
IIN revH DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225		Purchased	No			220	Each	622.0000	38	38			
---------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--



Insert

Location	Loc Qty	Loc Code
ST282	622	
110768	213	
117717	409	

AN3C5A		Purchased	No			230	Each	1,381.000	34	34			
--------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Bolt

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1374	
116419	28	
116549	54	
117343	500	
117764	300	
117872	492	

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Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

240.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

239

111982

2

116419

23

116549

2

116704

12

117619

50

117688

100

117872

50

AN6C44A

Purchased

No

230

Each

85.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

83

117763

31

117950

50

118112

2

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

83.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP

40

117511

40

FP-A

8

115960

1

116874

7

ST345

34

117834

34

ST346

1

114442

0

115188

0

115960

1

AN960C10L

NAS1149C0332
R

Purchased

No

230

Each

0.0000

38

38



washer

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER

D2745

Manufactured

No

230

Each

276.0000

8

8



Bushing

Location

Loc Qty

Loc Code

FP-A

276

68248

41

69529

155

69816

80

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3488-042

Manufactured No

230 Each

16.0000 1 1



Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

16

62003

2

65099

3

68109

11

D3492-1

Manufactured No

230 Each

132.0000 8 8



Plug

Location

Loc Qty

Loc Code

FP

132

69531

8

69819

52

70689

72

D3492-3

Manufactured No

230 Each

124.0000 8 8



Plug

Location

Loc Qty

Loc Code

FP

124

69822

44

70692

80

D3535-25

Manufactured No

230 Each

36.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP018

36

62233

1

69284

10

69743

25

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 5

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230 Each

37.0000 1 1



Gasket

Location

Loc Qty

Loc Code

FP012

37

68351

11

70780

26

D3537-1

Manufactured No

230 Each

13.0000 3 3



Wearpad

Location

Loc Qty

Loc Code

FP017

13

69278

6

69817

7

D3631-1

Manufactured No

230 Each

387.0000 8 8



Washer

Location

Loc Qty

Loc Code

ST072

387

68062

387

D3672-1

Manufactured No

230 Each

1,122.000 8 8



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1096

64177

596

66821

500

ST077

26

52505

26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 6

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 2.0000 1 1



Wearplate



Location Loc Qty Loc Code

FP017 2

62239 2

D3793-1 Manufactured No 230 Each 14.0000 1 1



Wearshoe



Location Loc Qty Loc Code

FP018 14

69285 14

D3793-3 Manufactured No 230 Each 14.0000 1 1



Wearshoe



Location Loc Qty Loc Code

FP018 14

68356 6

69283 8

D3794-1 Manufactured No 230 Each 36.0000 1 1



Gasket



Location Loc Qty Loc Code

FP010 36

68355 12

70779 24

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

29.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP010

17

68357

17

FP018

12

70812

12

MS21043-6

Purchased

No

230

Each

445.0000

4

4



NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

425

112314

415

117887

10

MS21083C8

Purchased

No

230

Each

97.0000

1

1



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

46

115884

0

117423

25

117677

21

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

198.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

96

117460

16

118077

80

FP-A

102

110915

91

115589

11

NAS1611-013

Purchased

No

230

Each

176.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

171

117291

31

117887

140

FP-A

5

116582

5

AN8C21A

Purchased

No

250

Each

101.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

76

117562

26

118045

50

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD816

Purchased No

250 Each

1.0000

2 2



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A

1

106043

1

D2741

Manufactured No

250 Each

39.0000

1 1



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

39

63589

9

69133

30

D3493-1

Manufactured No

250 Each

83.0000

2 2



Washer

Location

Loc Qty

Loc Code

ST062

83

68253

23

70697

60

D3532-1

Manufactured No

250 Each

49.0000

2 2



Spacer

Location

Loc Qty

Loc Code

ST065

49

66949

9

69895

40

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 10

Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

97.0000

2

2



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST293

50

118077

50

ST303

46

115884

0

117423

25

117677

21

D2600-3-BENT

Manufactured

No

110

Each

18.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG

18

66875

8

68137

1

70142

9

D2744

Manufactured

No

110

Each

5.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

5

62715

1

65086

4

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B 11/07/12

BEL 07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71499

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

5.0000

1

1



350 I Beam



Location

Loc Qty

Loc Code

LG

5

69886

5

D2743

Manufactured No

160

Each

163.0000

8

8



Crossbolt Spacer



Location

Loc Qty

Loc Code

LG

105

69818

105

LG001

58

67766

4

68251

54

D3490-3

Manufactured No

160

Each

77.0000

4

4



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

77

68952

18

70768

59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 12

Work Order ID: 71499



Parent Item: D350-636-012



Parent Item Name: Skidtube RH

Start Date: 7/5/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

97.0000

4

4



Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	95	
67773	5	
69510	30	
69823	60	
LG001	2	
62450	2	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3637-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

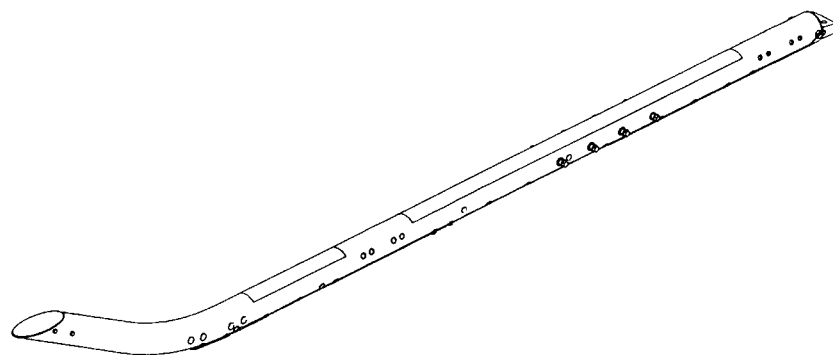
GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL Δ
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL Δ

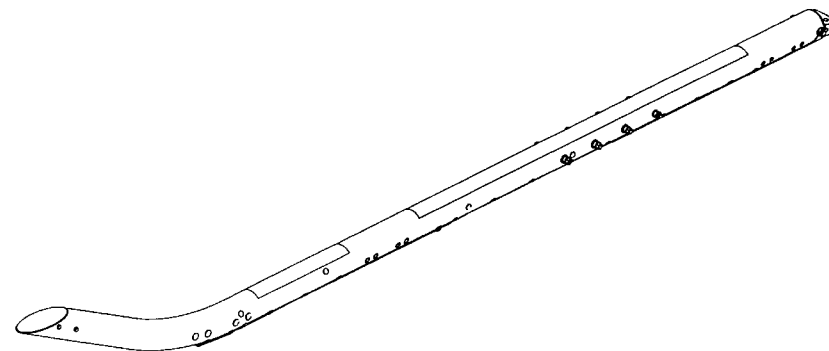
RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NGR 05-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>for</i>		
DRAWN	<i>for</i>		
CHECKED	<i>for</i>		
MFG. APPR.	<i>for</i>		
APPROVED	<i>for</i>		
DE APPR.	<i>for</i>		
DATE	08.07.16		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2750-041 350 SKIDTUBE ASSEMBLY, LH

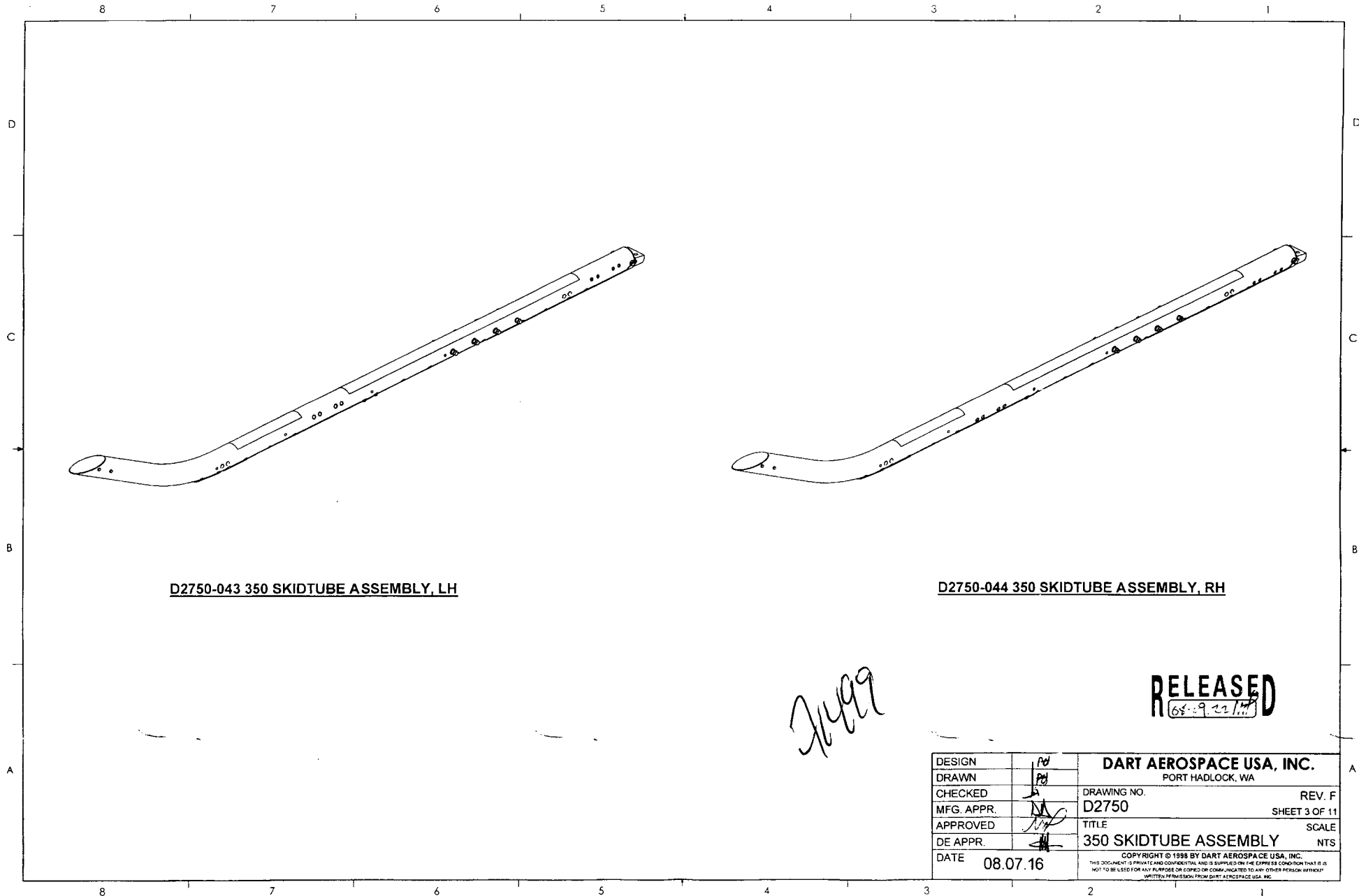


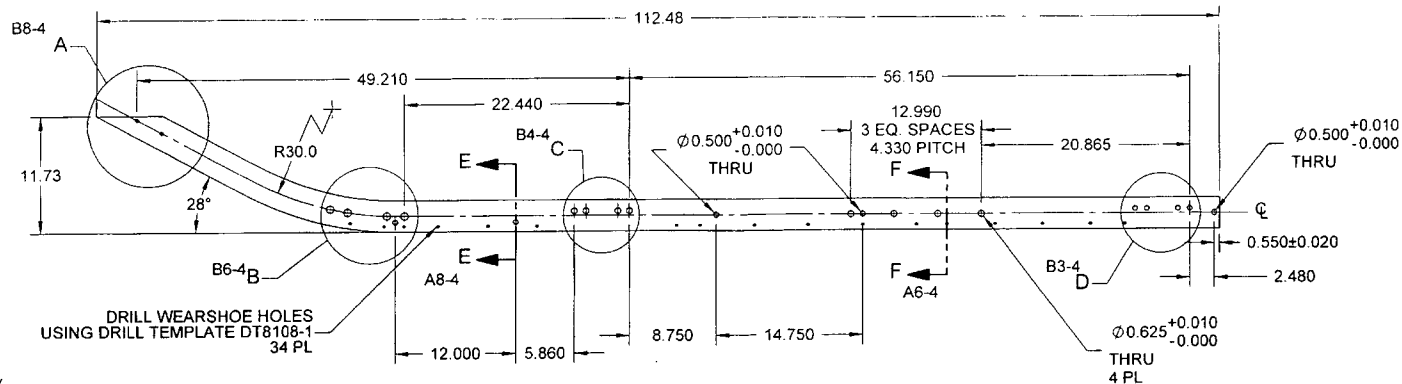
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
158 09 22 1997

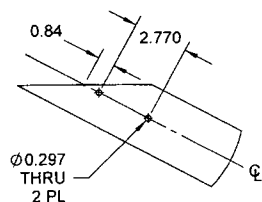
Handwritten signature/initials

DESIGN	PC1	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	NY	D2750	SHEET 2 OF 11
APPROVED	NY	TITLE	SCALE
DE APPR.	NY	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

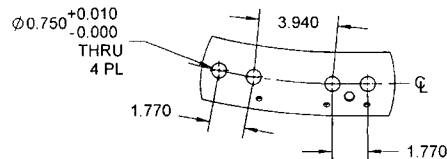




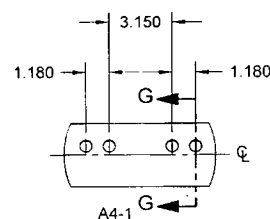
D2750-1 LH SKIDTUBE



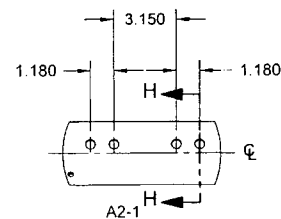
DETAIL A
SCALE 2X



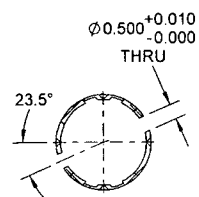
DETAIL B
SCALE 2X



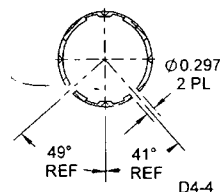
DETAIL C
SCALE 2X



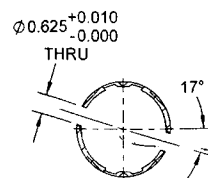
DETAIL D
SCALE 2X



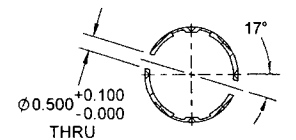
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



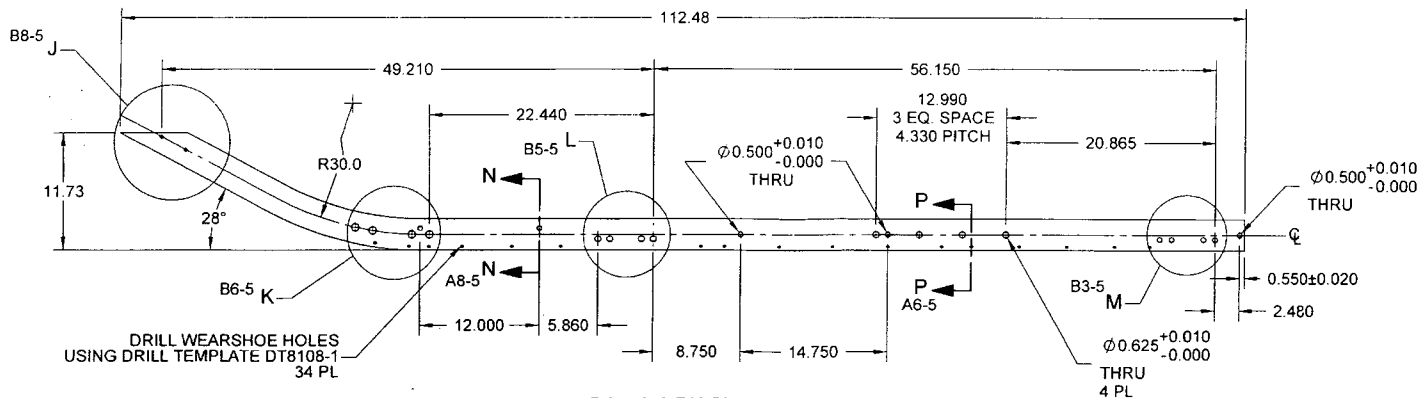
SECTION G-G
SCALE 3X, 4 PL



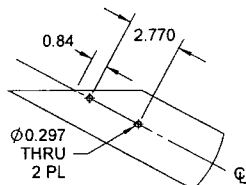
SECTION H-H
SCALE 3X, 4 PL

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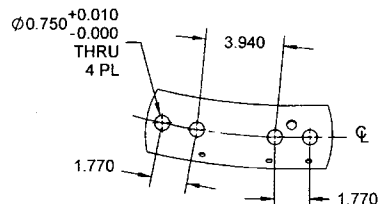
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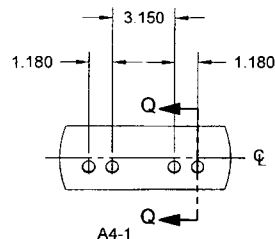
D2750-2 RH SKIDTUBE



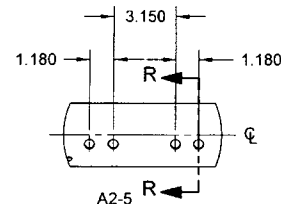
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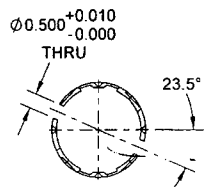
DETAIL K
SCALE 2X



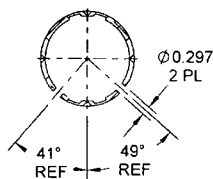
DETAIL L
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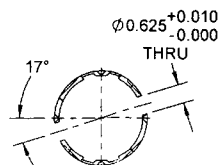
DETAIL M
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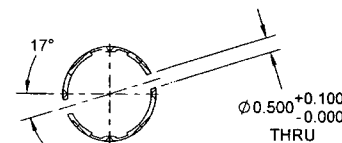
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

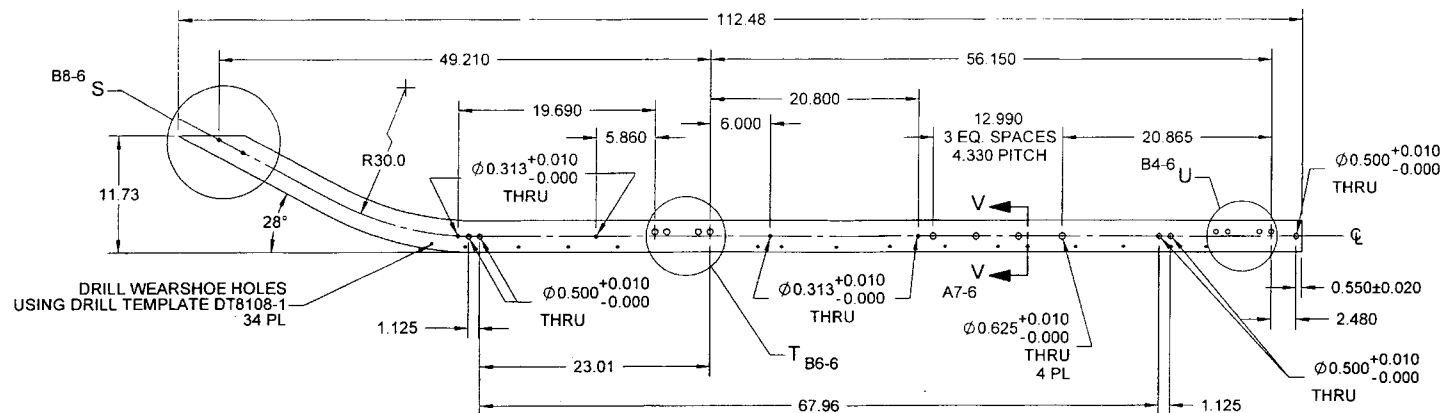


SECTION R-R
SCALE 3X, 4 PL

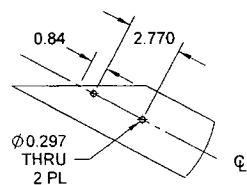
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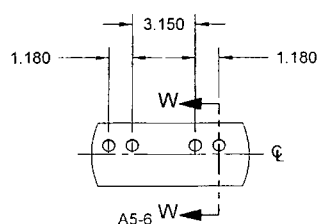
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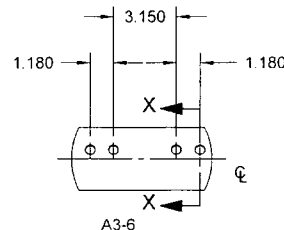
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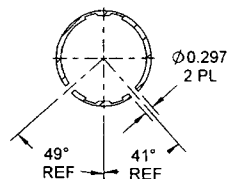
DETAIL S
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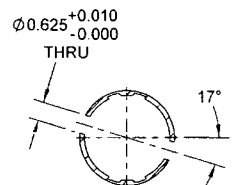
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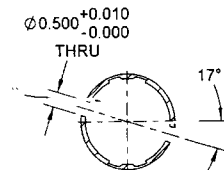
DETAIL U
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SECTION V-V
SCALE 3X, 17 PL



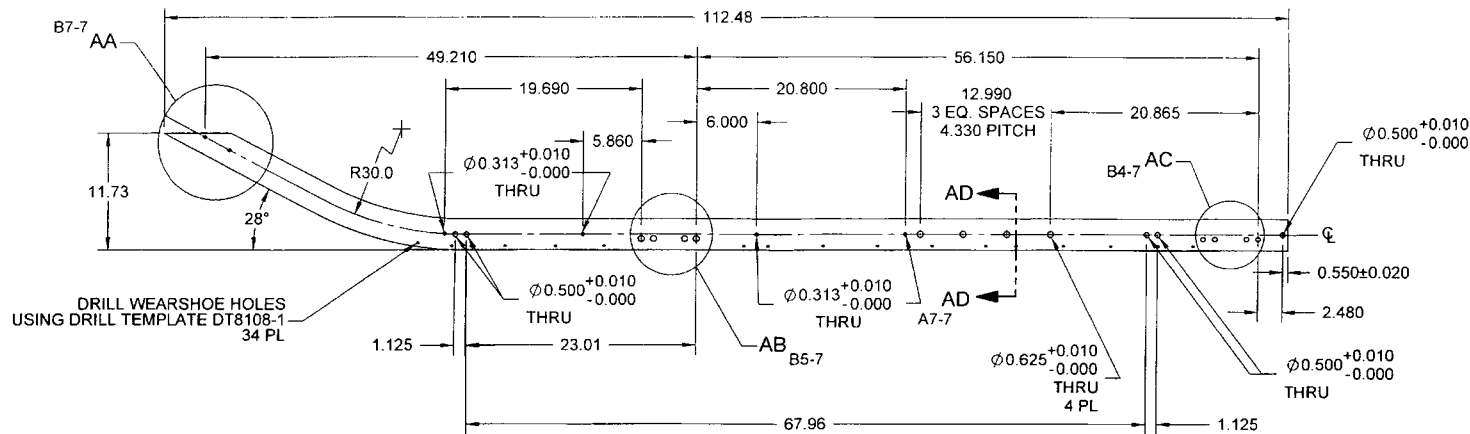
SECTION W-W
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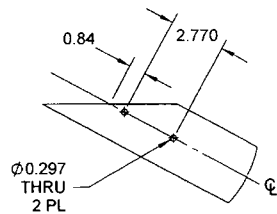
SECTION X-X
SCALE 3X, 4 PL

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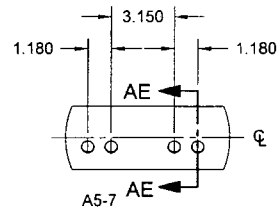
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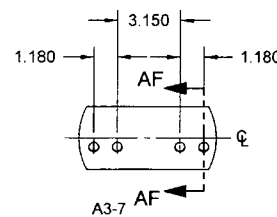
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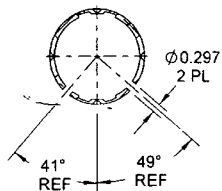
DETAIL AA
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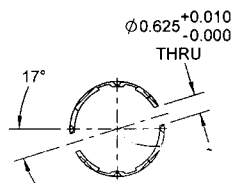
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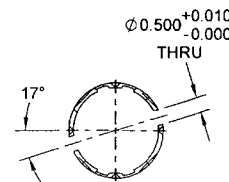
DETAIL AC
SCALE 2X









SECTION AD-AD
SCALE 3X, 17 PL



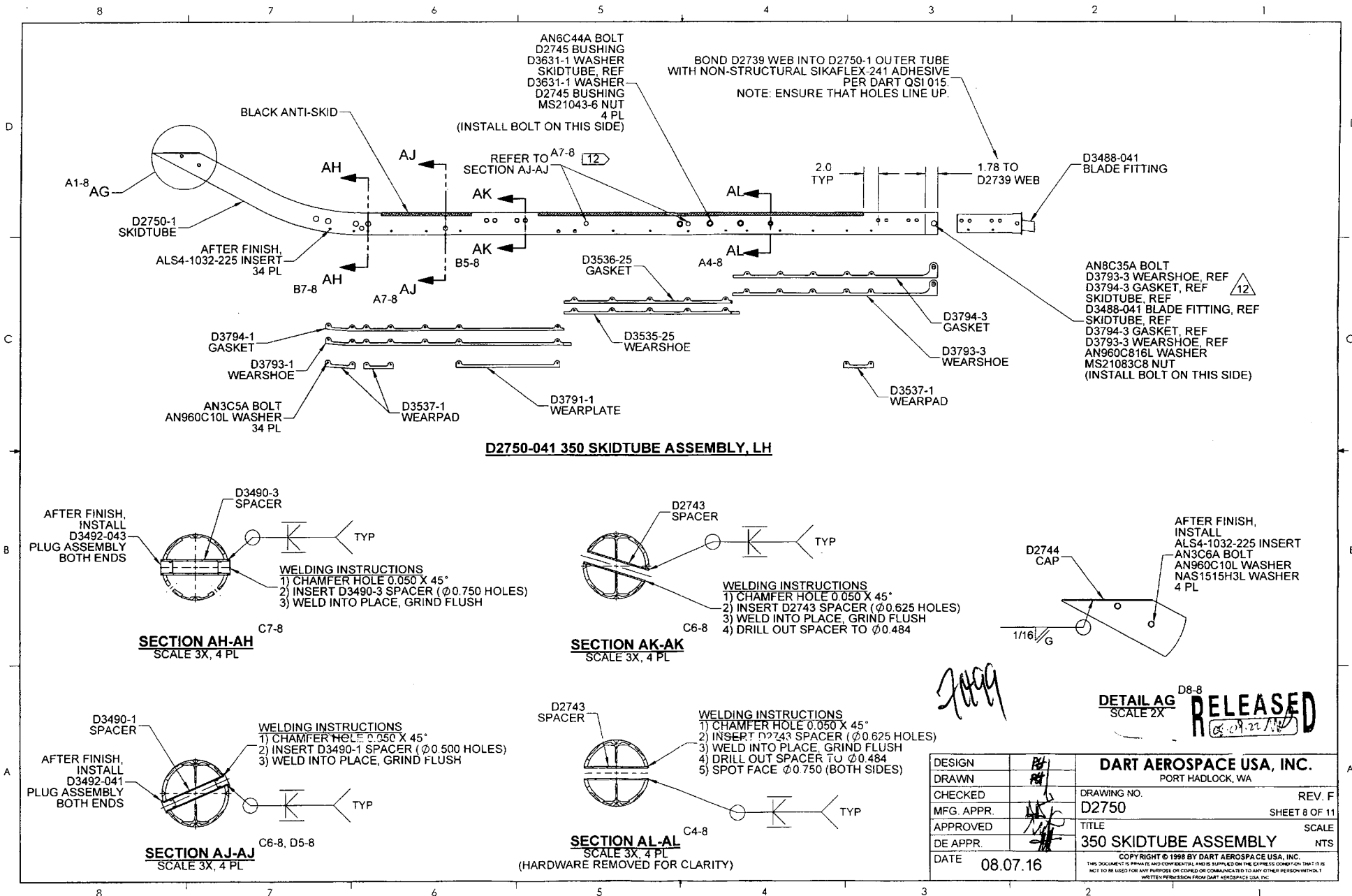
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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8

7

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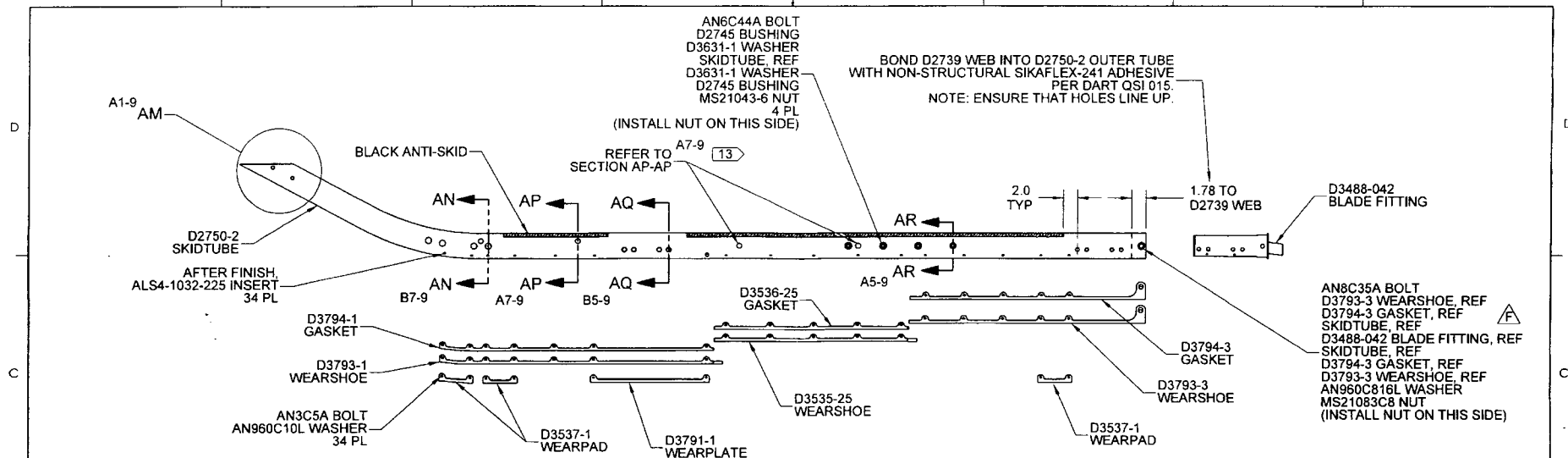
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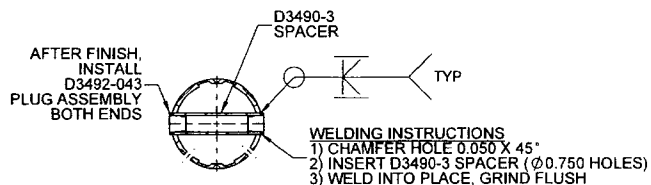
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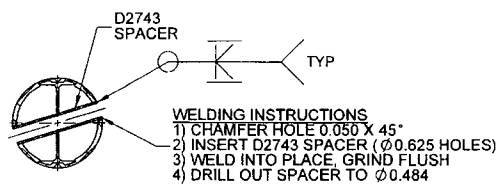
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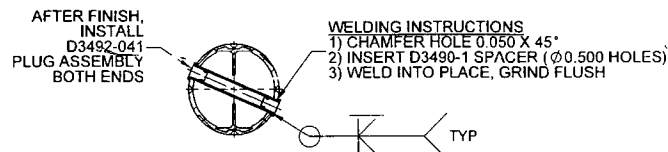
D2750-042 350 SKIDTUBE ASSEMBLY, RH



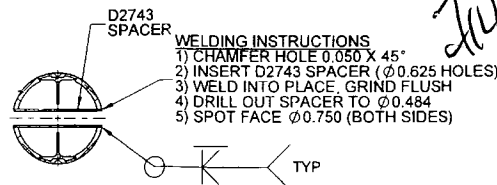
SECTION AN-AN
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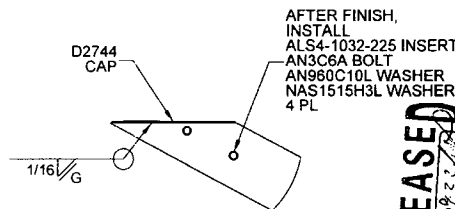
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP
SCALE 3X, 4 PL



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL AM
SCALE 2X

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